

Work Order ID 58410

May 6, 2010 8:28:01 AM



Page 1

Item ID: DSK080

Accept



Setup Start



Revision ID:

Stop



Item Name: D2896-1 TURNING DETAIL

Start Date: 06/05/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 13/05/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

RL

Date: 10-5-08

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw /
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

DSK080

Rev A

100

0.00



MORI SEIKI CNC LATHE LARGE

Doosan

Memo

0.00

Doosan Lathe

Turn blank as per Folio FA167

SL 10/07/10

10

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

SL 10/07/10

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

SL 10/07/12

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 58410

May 6, 2010 8:28:01 AM



Page 2

Item ID: DSK080

Accept



Setup Start



Revision ID:

Item Name: D2896-1 TURNING DETAIL

Stop



Start Date: 06/05/2010 Start Qty: 10.00



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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and Stock in Kanban ☐ Location: CNC

LF 10/07/12

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10-7-12

10-7-12

W/O:		WORK ORDER CHANGES						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

May 6, 2010 8:28:06 AM

Page 1

Work Order ID: 58410



Parent Item: DSK080



Parent Item Name: D2896-1 TURNING DETAIL

Start Date: 06/05/2010

Required Date: 13/05/2010

Comments: IPP rev A. 08.03.13 new issue EC

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D6104-011		Manufactured	No				Each	10.0000	1			



17-4 SS Roundbar 6.50"OD



Location

Loc Qty

Loc Code

MAT43

10

41969

10

10 JL 10/07/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROL

SUBJECT TO A

WITHOUT NOTICE

WORK ORDER

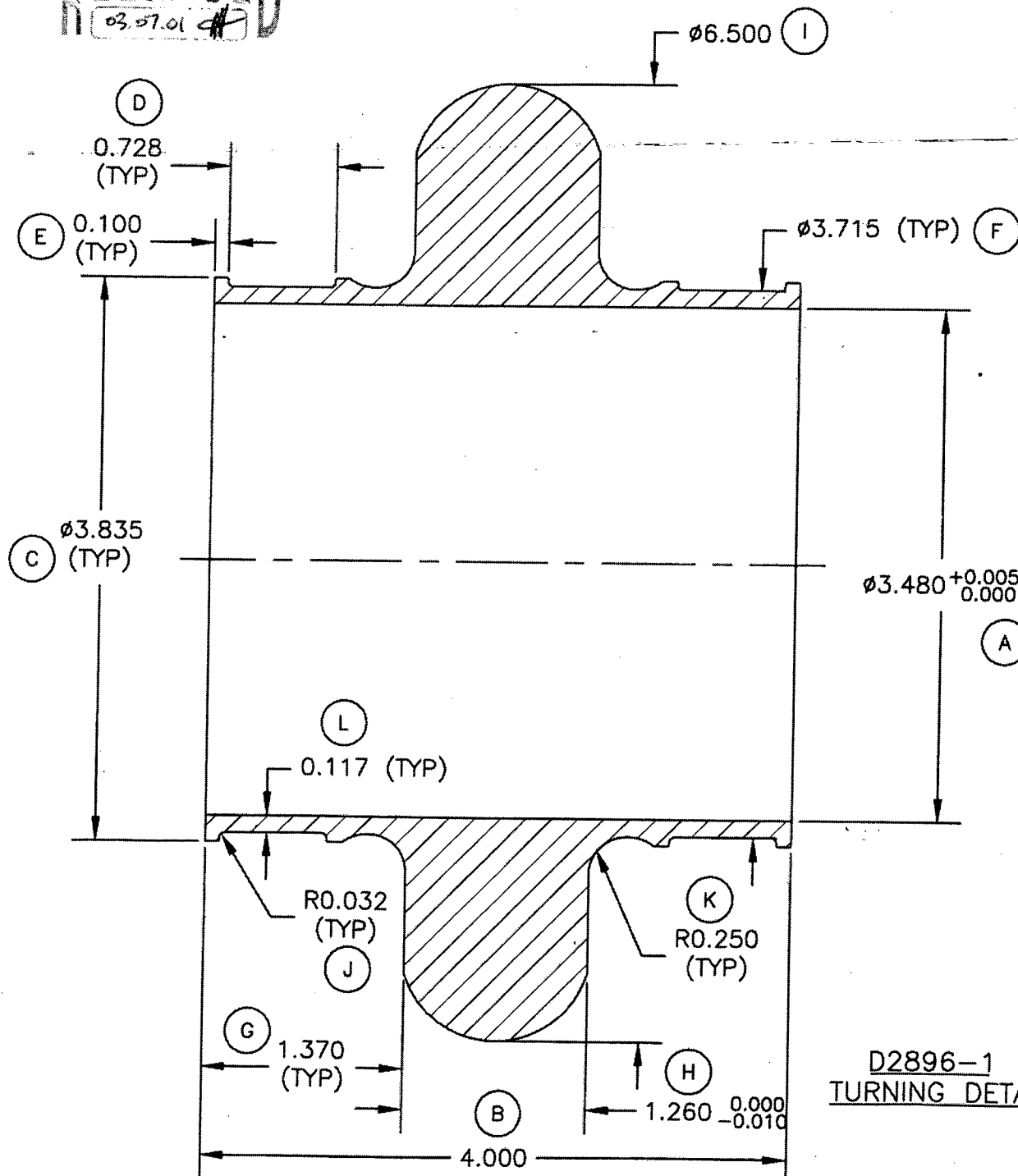
NO. 58410



10-5-06

DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. DSK 080	REV. A SHEET 1 OF 1
DATE 03.05.20		TITLE TURNING DETAIL FOR D2896-1	SCALE 1:1
A	03.05.20	NEW ISSUE	

RELEASED
03.07.01



D2896-1
TURNING DETAIL

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	58410
Description: Turning Detail for D2896-1		Part Number:	DSK080
Inspection Dwg: DSK080	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	3.480	3.485		3.480	3.480	3.480	3.480	3.480
B	3.990	4.010		4.001	4.002	4.000	4.000	4.000
C	3.825	3.845		3.835	3.835	3.835	3.835	3.835
D	0.718	0.738		.728	.728	.728	.728	.728
E	0.090	0.110		.101	.101	.101	.101	.101
F	3.705	3.725		3.716	3.716	3.716	3.716	3.716
G	1.360	1.380		1.373	1.373	1.373	1.373	1.373
H	1.250	1.260		1.258	1.257	1.257	1.257	1.257
I	6.490	6.510		6.498	6.498	6.499	6.499	6.499
J	0.022	0.042		.032	.032	.032	.032	.032
K	0.240	0.260		.250	.250	.250	.250	.250
L	0.107	0.127		.119	.119	.119	.119	.119
M								
N								
O								
P								

Measured by: SL Date: 10/07/07

Audited by: SL Date: 10/07/12

Prototype Approval: _____ Date: _____

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	<u>SL</u>

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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DART AEROSPACE LTD		Work Order:	58410
Description: Turning Detail for D2896-1		Part Number:	DSK080
Inspection Dwg: DSK080		Rev: A	Page 1 of 1

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B	3.990	4.010		4.001	4.001	4.000	4.000	4.000
C	3.825	3.845		3.835	3.835	3.835	3.835	3.835
D	0.718	0.738		.728	.728	.728	.728	.728
E	0.090	0.110		.101	.101	.101	.101	.101
F	3.705	3.725		3.716	3.716	3.716	3.716	3.716
G	1.360	1.380		1.373	1.373	1.373	1.373	1.373
H	1.250	1.260		1.257	1.258	1.257	1.257	1.257
I	6.490	6.510		6.499	6.499	6.499	6.499	6.499
J	0.022	0.042		.032	.032	.032	.032	.032
K	0.240	0.260		.250	.250	.250	.250	.250
L	0.107	0.127		.119	.119	.119	.119	.119
M								
N								
O								
P								

Measured by: SK **Date:** 10/07/07

Audited by: SD **Date:** 10/07/12

Prototype Approval: **Date:**

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	SK